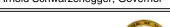
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-001282

Address: 333 Burma Road **Date Inspected:** 22-Jan-2008

City: Oakland, CA 94607

OSM Arrival Time: 1900 **Project Name:** SAS Superstructure **OSM Departure Time:** 730 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes No Zhu Zhong Hai **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Caltrans mock up

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Zhu Zhong Hai was observed monitoring welding activities at the workstation. Caltrans QA Inspector observed SMAW in progress of fill passes on 77m Diaphragm Sub Assembly MA9 to SA95; weld joint MUA-MA1 F/F 20. The weld joint is a Complete Joint Penetration weld in the 3G position. The approved welder #040690 Yang Lei was using approved welding procedure specification WPS-B-T4313-TC-P5-1. Caltrans QA Inspector observed QC Zhu Zhong Hai verify welding parameters. Preheat and interpass temperatures were verified during welding activities and were within approved WPS minimum range and maximum range. SMAW welding consumable is verified and identified as classification E7018-1, 4mm in diameter.

Summary of Conversations:

As identified within the contents of this report.

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By: Hernandez,Dan Quality Assurance Inspector **Reviewed By:** Cuellar,Robert QA Reviewer